

Date: Wednesday, 7/4/2007 10:17:33 AM
 User: Kim Johnston

Process Sheet

SPLIT-1

| | | | | | | |
|-----------------------|---------------------------------------|------------------------|------------------|-----------|------------|------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : WEARPAD | | |
| Job Number | : 33285 | | | | | |
| Estimate Number | : 12711 | | | | | |
| P.O. Number | : | | Part Number | : | D35373 | |
| This Issue | : 7/4/2007 | S.O. No. : | Drawing Number | : | D3537 RF/C | |
| Prsht Rev. | : NC | | Project Number | : | N/A | |
| First Issue | : // | Type : SMALL /MED FAB | Drawing Revision | : | C | |
| Previous Run | : 32789 | | Material | : | | |
| Written By | : | | Due Date | : | 7/22/2007 | Qty: 40 Jnl: Eac |
| Checked & Approved By | : | <i>7/4/07.04</i> | | | | (29) |
| Comment | : Est Rev:A | New Issue 07-02-14 JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|-----------------------------|
| 1.0 | M304S16GA | 304/316 .063 Sheet | |
| | | Comment: Qty.: 0.1512 sf(s)/Unit Total : 6.0480 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: 4105061 | |
| 2.0 | WATER JET | FLOW WATER JET | |
| | | Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <i>C</i> Prog Rev: <i>C</i> | |
| | | 2-Deburr if necessary | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | |
| 4.0 | QC8 | SECOND CHECK | |
| | | Comment: SECOND CHECK | |
| 5.0 | BRAKE NC | NC BRAKE | |
| | | Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158 | |
| | | | FF 07-08-07 BB 07-08-108 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 11/4/2007 10:17:33 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33285

Part Number: D35373

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

En 07/08/08

148

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty

Description

Batch

A/R

2059B Hardcoat

P105138

Weld hardcoat as per Dwg D3437

FC 07/08/15

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 104 846

BL/m-f 07-08-15

20

11.0 QC3

INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP 18

m-f 07/08/15

20

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11.07.08.17

Job Completion



11.07.08.16

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NOTE: Date & initial all entries

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|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 33285 |
| Description: Wearpad | Part Number: | D3537-3 |
| Inspection Dwg: D3537 | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | Bob | Audited by: | ✓ | Prototype Approval: | N/A |
| Date: | 07/07/20 | Date: | 07/07/23 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-----------------|----------|
| A | 07.05.10 | New Issue | KJ/JLM <i>✓</i> | <i>E</i> |

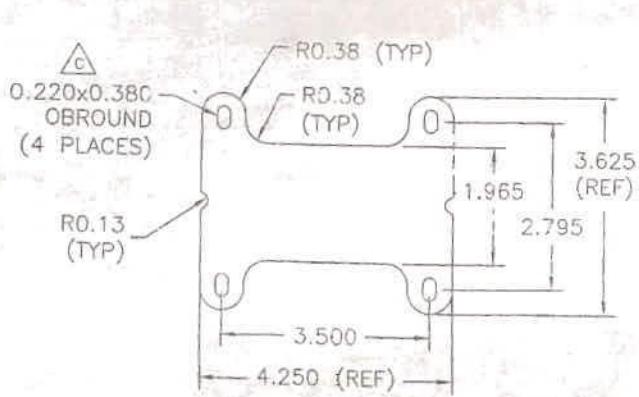
| W/O: | | WORK ORDER CHANGES | | | | | |
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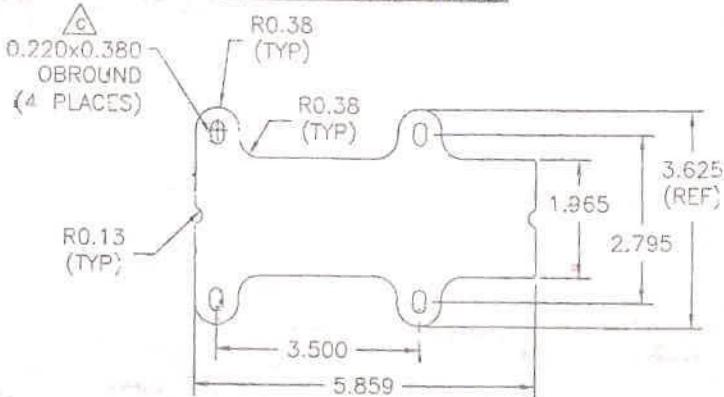
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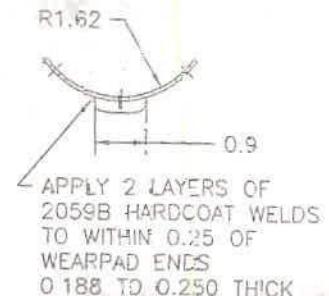
D3537-1F FLAT PATTERN



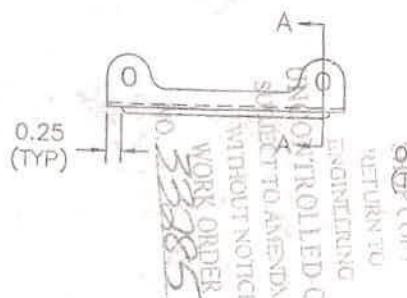
D3537-3F FLAT PATTERN



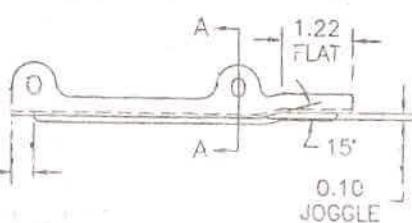
SECTION A-A



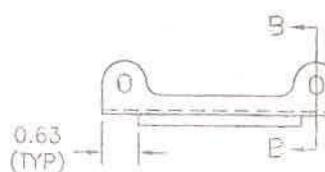
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
2) BREAK ALL SHARP CORNERS 0.063 MAX
3) WELD PER QSI 004
4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

1. *What is the primary purpose of the study?*

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AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM

| | | |
|----------|------------|--|
| C | 07.04.13 | WIDEN TAB TO 0.380; WELD PATTERN |
| B | 07.03.20 | ADD AMS 5513 AND AMS 3524 |
| A | 06.11.06 | NEW ISSUE |
| DESIGN | REISSUE BY | |
| CB | PH | DART DART AEROSPACE USA, INC. PO BOX 14600, WA |
| CHECKED | APPROVED | DRAWING NO. REV. C D3537 |
| DATE | | 1 |
| 07.04.13 | | SCALE |
| | | 12 |
| | | |

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